

D3697-041 B82547

## Work Order ID 82542

Monday, April 02, 2012 3:43:05 PM

\*82542\*

April 18 Page 1

Item ID: D3690-041 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Glareshield Assembly

Start Date: 4/2/2012 Start Qty: 1.00 \*1\*

Required Date: 4/17/2012 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3690	Rev C

100	Pick Kit	0.00							
*100*									
Packaging	Memo	0.00							
Packaging									

110	Small Fab	0.00							
*110*									
Small Fab	Memo	0.00							
Small Fab	1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690								
	2- scribe batch # and part # as per dwg								

120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

S. K. K. K.

1x 12/04/13

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*82542\***

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Item ID: D3690-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Glareshield Assembly  
 Start Date: 4/2/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 4/17/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	SprayPaint	0.00							
<b>*130*</b>									
SprayPaint	Memo	0.00							
Spray Painting	1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg								
	2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2								
140	QC14- Inspect Spray Paint	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
145	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

AS 12-4-18 (1)

BT 12-04-19 (X1)

12/4/23

MR 12-04-20

ID 4, STOCK

PP082541

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 02, 2012 3:43:10 PM

Page 1

Work Order ID: 82542

\*82542\*

Parent Item: D3690-041

\*D3690-041\*

Parent Item Name: Glareshield Assembly

Start Date: 4/2/2012

Required Date: 4/17/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-04-29 new issue DD verified by:ec  
 IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec  
 IPP Rev:C 08-09-08 added painting DD verified by:EC  
 IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD3 *AN960.ID3* Washer		Purchased	No				Each	141.0000		2			12/04/13 FF
				<u>Location</u>				<u>Loc Qty</u>					
				ST337A				141					
					107989			141		2			
CR3213-4-03 *CR3213-4-03* rivet		Purchased	No				Each	174.0000		35			12/04/13 FF
				<u>Location</u>				<u>Loc Qty</u>					
				ST331				100					
					120521			100		35			
				ST332				74					
					116081			74					
D3690-1 *D3690-1* Glareshield		Manufactured	No				Each	0.0000		1			12/04/13 FF
D3697-041 *D3697-041* Tube Assembly		Manufactured	No				Each	0.0000		1			12/04/13 FF

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Monday, April 02, 2012 3:43:10 PM

Work Order ID: 82542

**\*82542\***

Parent Item: D3690-041

**\*D3690-041\***

Parent Item Name: Glareshield Assembly

Start Date: 4/2/2012

Required Date: 4/17/2012

Start Qty: 1.00

Required Qty: 1.00

D3698-1

Manufactured No

Each

5.0000

1

**\*D3698-1\***

Support Angle

\*\*

① FF 12/04/13

Location

Loc Qty

Loc Code

ST241A

5

59244

5

Each

12,478.00

1

2

\*\*

① FF 12/04/13

MS20426AD3-5

Purchased

No

**\*MS20426AD3-5\***

Rivet

Location

Loc Qty

Loc Code

ST316

12478

4179

664

4444

5654

4533

6160

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

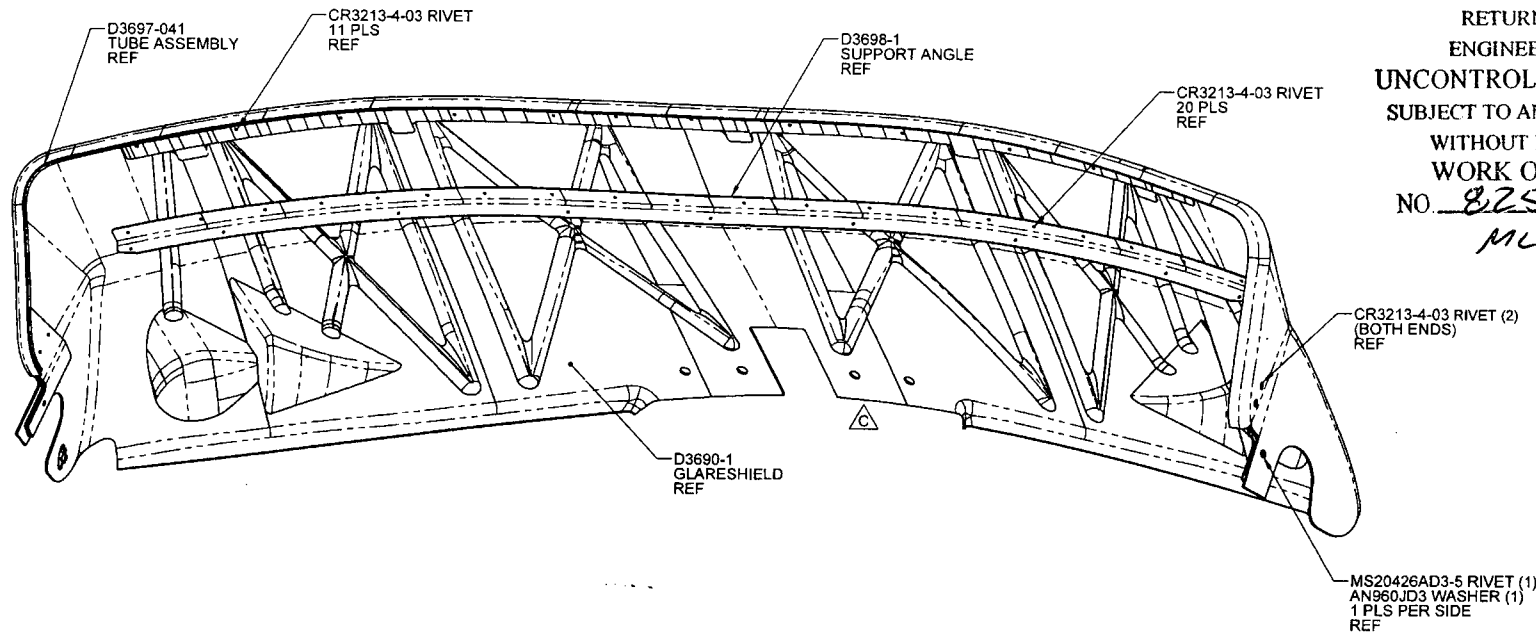
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82542

MLJ  
12/04/02

RELEASED  
08-09-02

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO 'HARD' CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A, B & C, 5. ADD MIN THICKNESS. SHEET 3 ZONE A, B	RF	08.06.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JA	DRAWING NO.	REV. C
MFG. APPR.	JE	D3690	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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△ TRANSFER DRILL Ø0.128  
FROM D3698-1 TO D3690-1  
INSTALL  
CR3213-4-03 RIVET, 20 PL  
RIVET HEAD ON GLARESHIELD  
OUTSIDE SURFACE

D3690-1  
GLARESHIELD  
REF

TRANSFER DRILL Ø0.098  
FROM D3697-041 TO D3690-1  
INSTALL  
MS20426AD3-5 RIVET  
AN960JD3 WASHER (ON GLARESHIELD  
OUTSIDE SURFACE)  
1 PER SIDE

TRANSFER DRILL Ø0.128  
FROM D3697-041 TO D3690-1  
INSTALL  
CR3213-4-03 RIVET 2  
BOTH ENDS

0.14  
REF

### SECTION A-A

EQUAL DIMENSION  
AT BOTH ENDS

TRANSFER DRILL Ø0.128  
FROM D3697-041 TO D3690-1  
INSTALL  
CR3213-4-03 RIVET, 11PL  
RIVET HEAD ON GLARESHIELD  
OUTSIDE SURFACE

TRANSFER DRILL Ø0.144  
AT THIS LOCATION  
FROM D3697-041 TO D3690-1  
(NO HARDWARE INSTALLED)

D3698-1  
SUPPORT ANGLE  
REF

### D3690-041 GLARESHIELD ASSEMBLY

#### NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

RELEASED  
08-09-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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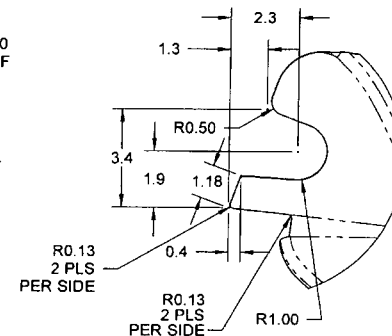
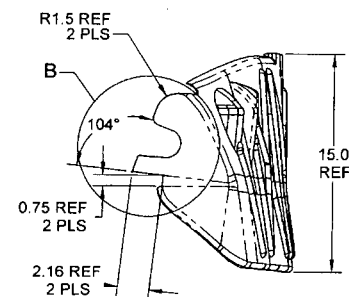
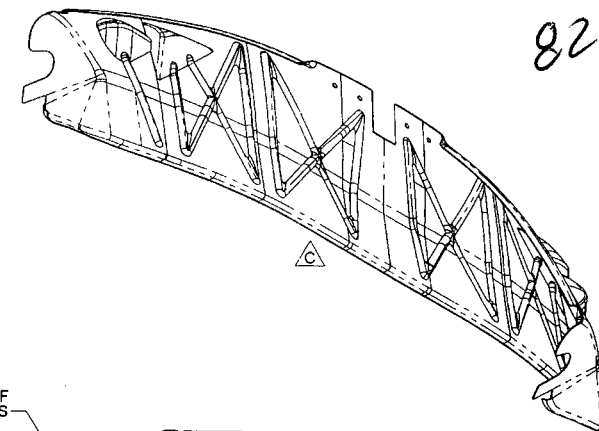
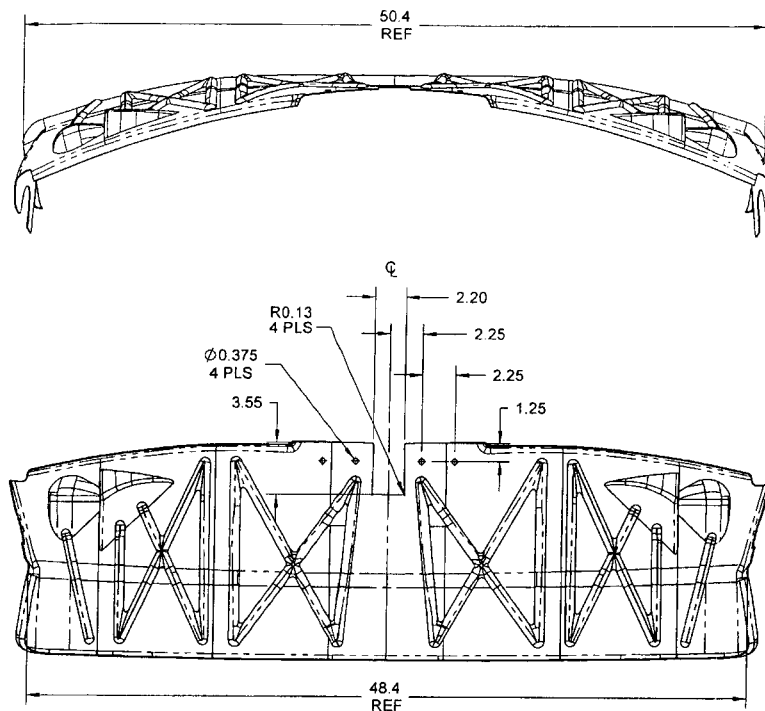
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# **D3690-1 GLARESHIELD**

## **NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022  
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

**RELEASED**  
02.07.04 MP

**DETAILB**  
SCALE 2X  
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3690</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>GLARESHIELD ASSEMBLY</b>	NTS
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